

Work Order ID 162517

Monday, June 05, 2017 9:28:56 AM

162517

Ship As 8

Page 1

Item ID: D4406-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Wearplate Assembly

Start Date: 6/8/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/15/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUN 07 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4406	D								

150

0.00

150

Large Fab

Memo

1.80

Large Fab

1- Weld D4407-043 to wearplate as per dwg D4406

304 S.S. Welding Rod

BATCH #: M134992

2- Transfer drill holes in bar

2 Q-L 17-08-03

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

② 17-08-03 PD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

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Start Date: 6/8/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/15/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165 *165* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04							<u>① 11-25-03 80</u>
170 *170* Small Fab Small Fab	QC5- Inspect part completeness to step on W/O Memo Apply coating as per dwg D4406	0.00 0.40							<u>2</u> <u>Jan</u> <u>17 08 09</u>
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04							<u>2</u> <u>DAS</u> <u>38</u> <u>9-89</u> <u>AUG 10 2017</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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		OTHER : ☐							

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
100						2	DAS 28 9-89	AUG 10 2017	
Packaging	Memo	0.02							
Packaging	LOCATION : FP002								
200	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89	AUG 10 2017	
200									
QC	Memo	0.20							
Quality Control									
							DAS 21 9-89	AUG 10 2017	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Page 1

Monday, June 05, 2017 9:28:53 AM

Work Order ID: 162517

162517

Parent Item: D4406-043

D4406-043

Parent Item Name: Aft Wearplate Assembly

Start Date: 6/8/2017

Required Date: 6/15/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev A 11.06.06new issue EC verified by:DD IPP rev B
12.02.06 as per dwg revPB1 DD verf:EC IPP REV:C 15.11.16
AS PER DWG PD1 DD VERF:JLM IPP REV:D 16.02.05 AS PER
DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4406-3		Manufactured	No			150	Each	5.0000	1	2			
D4406-3									**				
Plate													

Q.L 17-08-03

Location	Loc Qty	Loc Code
WA001	3	
152192	3	
WA002	2	
145572	2	

D4407-043

Manufactured No

150

Each

12.0000

2

4

D4407-043

Bar Weldment

**

Q.L 17-08-03

Location	Loc Qty	Loc Code
WA002	12	
152220	10	
153762	2	

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

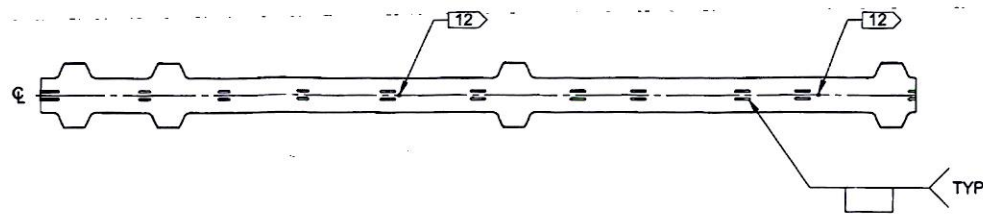
QA Closed: _____ Date: _____

Work Order update only ☐

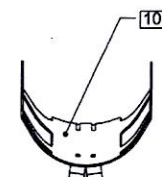
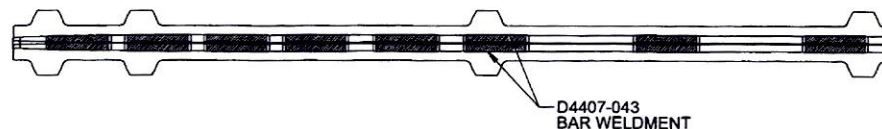
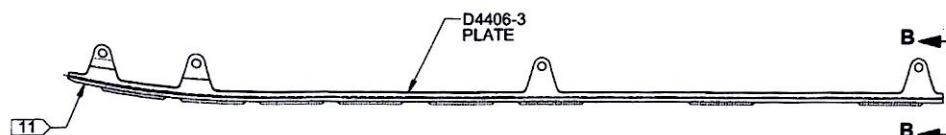
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4406-043	WEARPLATE ASSY
1	1	D4406-3	PLATE
2	2	D4407-043	BAR WELDMENT

△



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162517 MJS
170607



VIEW B-B
SCALE 2X

D4406-043 AFT WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.70 lbs
- 8) WELDING: PER QSI 004
- 9) N/A
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING.
- 12) TRANSFER $\varnothing$ 0.188 HOLES FROM D4406-3 TO D4407-043

RELEASED
2016-02-08

APPROVED

DESIGN	RF
DRAWN	DB
CHECKED	ML
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	15.10.14

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4406** REV. D
SHEET 2 OF 5
TITLE **WEARPLATE ASSY** SCALE NTS

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